

Work Order ID 83793

April-26-12 7:41:04 AM

83793

Page 1

Item ID: D4108-9

Revision ID:

Item Name: Fitting, Litter Door

Start Date: 4/26/12 Start Qty: 2.00

Required Date: 4/26/12 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

NR1***NR2******N900040100***

Setup

Stop

NS1***NS2***

Cust Item ID:

Customer:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4108

100

100

Bandsaw

Jcaspa Bandsaw

8003

Cut blanks as per folio

Memo

cut to 3.750"

0.00

0.00

*B.A 12/04/26**2 0*

110

110

HAAS I

HAAS CNC vertical machine #1

Memo

MILL AS PER DWG AND FOLIO FA964

FOLIO REV: AADWG REV: B

0.00

0.00

*B.A 12/04/26**2 0*

DEBURR

Work Order ID 83793

April-26-12 7:41:04 AM

83793

Page 2

Item ID: D4108-9

Revision ID:

Item Name: Fitting, Litter Door

Start Date: 4/26/12 Start Qty: 2.00

Required Date: 4/26/12 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

D.A 12/04/26

2

✓

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Srk 4/26

② f

132

Chemical Conversion Coat per QSI005 4.1

0.00

132

HandFinish

Memo

0.00

Hand Finishing

② 7/6/12-4-26

Work Order ID 83793

April-26-12 7:41:04 AM

83793

Page 3

Item ID: D4108-9

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fitting, Litter Door

Start Date: 4/26/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/26/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

133

QC3- Inspect Part Finish

0.00

133

QC

Memo

0.00

Quality Control

2X ✓

M/T
12/24/26

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

Qty x1 on w/o 83780

D4108-019

128

2X

12/24/27

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 12/04/27

12/04/27

Picklist Print

April-26-12 7:41:03 AM

Page 1

Work Order ID: 83793

Parent Item: D4108-9

Parent Item Name: Fitting, Litter Door

Start Date: 4/26/12

Required Date: 4/26/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-10-12 VERIFIED BY:DD
rev.B DD verf:EC

IPP Rev:B 10.12.03 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.500		Purchased	No			100	f	15.0061	0.3125	0.6578947			
6061-T6 Bar 2.00 x 3.50													

Location

Loc Qty

Loc Code

MAT009

15.0061

112764

0.7284

118182

11.4527

→ 118641

2.825


0.6578 ^{4x}

B.A 12/04/26


DART AEROSPACE LTD	Work Order: 83793
Description: Fitting Litter door	Part Number: D4108-9
Inspection Dwg: D4108 Rev: B	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

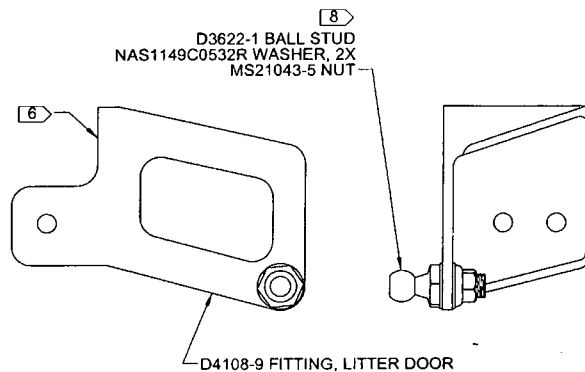
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.78	+/- .030	1.778	✓		Vern	GA-01
0.100	+/- .010	0.098	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
0.125	+/- .010	0.120	✓		Vern	GA-01
R0.25	+/- .030	R0.250	✓		R-6	ref.
0.125	+/- .010	0.121	✓		Vern	GA-01
1.48	+/- .030	1.477	✓		"	"
R0.13	+/- .030	R0.125	✓		R-6	ref.
0.66	+/- .030	0.660	✓		Vern	GA-01
0.37	+/- .030	0.367	✓		"	"
φ0.234	+ .005 / - .001	φ0.238	✓		"	"
0.100	+/- .010	0.096	✓		"	"
0.40	+/- .030	0.398	✓		"	"
2.06	+/- .030	2.060	✓		"	"
φ0.316	+ .006 / - .001	φ0.317	✓		"	"
0.27	+/- .030	0.269	✓		"	"
2.57	+/- .030	2.569	✓		"	"
2.27	+/- .030	2.269	✓		"	"
0.100	+/- .010	0.097	✓		"	"
0.40	+/- .030	0.397	✓		"	"
1.06	+/- .030	1.062	✓		"	"
φ0.234	+ .005 / - .001	φ0.238	✓		"	"
R0.25	+/- .030	R0.250	✓		R-6	ref.

Measured by: D.A	Audited by: 	Preliminary Approval:
Date: 12/04/26	Date: 12/04/26	Date:

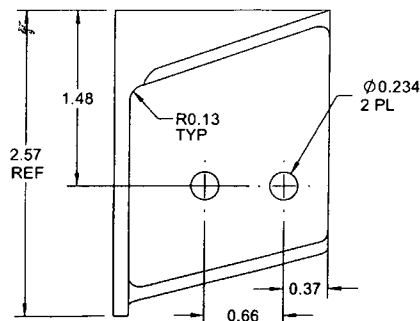
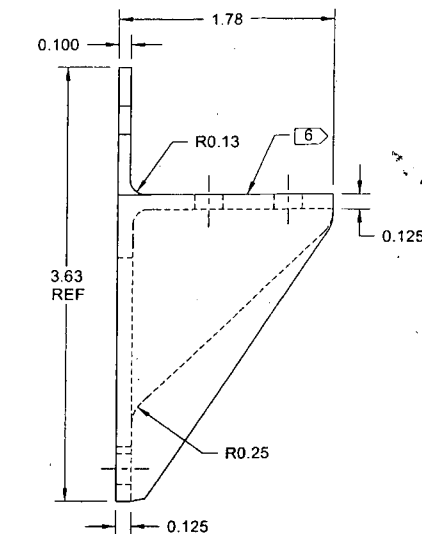
Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

 10.04.15

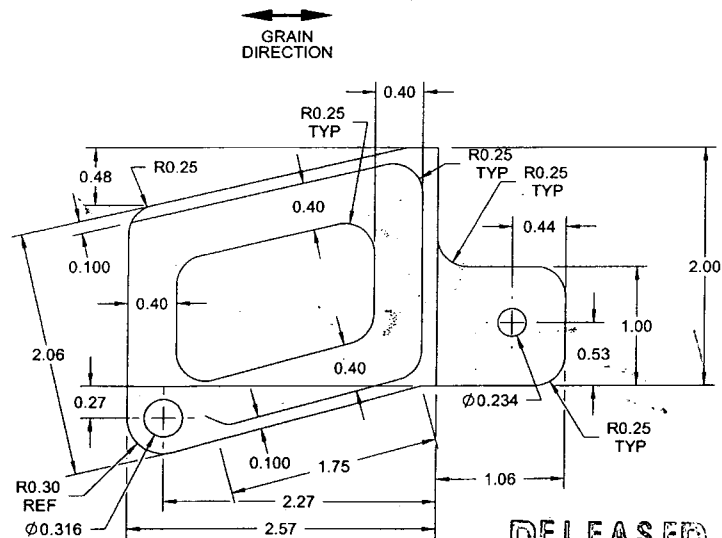
Qty	Part Number	Description
-049	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY






83793



D4108-9 FITTING, LITTER DOOR

RELEASED
2010-11-30

- NOTES:**
- 1) MATERIAL -9: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B221 REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: P/N D4108-X & B/N PER QSI 044 6.1
 - 7) WEIGHT -049: 0.19 lbs
 - 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JPH	DRAWING NO.	REV. B
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE	10.11.01	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			